

Work Order ID 76541

November-16-11 1:38:54 PM

76541

Page 1

Item ID: D4034-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Upper Rib Assembly
 Start Date: 16/11/2011 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 22/11/2011 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4034	B								

100 Weld per dwg A/R S.S. rod Batch: 4115778 0.00

100

Large Fab

Memo 0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib as per dwg

12-01-04 3X

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo 0.00

Quality Control

12-01-04

3X

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo 0.00

Quality Control

12/01/04

(43)

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 Start Date: 16/11/2011 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 22/11/2011 Req'd Qty: 3.00 ***3*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	<i>Back call</i>								
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12.01.04 3x

12/1/19

MF 12-01-06

Picklist Print

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Work Order ID: 76541

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Parent Item: D4034-043

D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 16/11/2011

Required Date: 22/11/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
PER DWG REV.B DD VERF:EC
IPP Rev:B as
IPP Rev:C 11.01.19 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D4034-1
D4034-1
Rib

Manufactured	No	100	Each	9.0000	1	3
--------------	----	-----	------	--------	---	---

**

Ae 12.01.03

Location	Loc Qty	Loc Code
----------	---------	----------

WA	9	
----	---	--

74780	9	
-------	---	--

* D4034-5
D4034-5
Rib

Manufactured	No	100	Each	2.0000	1	3
--------------	----	-----	------	--------	---	---

**

Ae 12.01.03

Location	Loc Qty	Loc Code
----------	---------	----------

WA	1	
----	---	--

67339	1	
-------	---	--

WA006	1	
-------	---	--

70343	1	
-------	---	--

Manufactured	No	100	Each	21.0000	1	3
--------------	----	-----	------	---------	---	---

**

Ae 12.01.03

Location	Loc Qty	Loc Code
----------	---------	----------

WA	21	
----	----	--

72963	1	
-------	---	--

74782	20	
-------	----	--

B75564

(X3)

Picklist Print

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Work Order ID: 76541

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Parent Item: D4034-043

D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 16/11/2011

Required Date: 22/11/2011

Start Qty: 3.00

Required Qty: 3.00

D4021-7

Manufactured No

100

Each

8.0000

1

3

✓ ***D4021-7***

Hoop

**

Ac ~~*12.01.03*~~ *12.01.03*

Location

Loc Qty

Loc Code

WA

8

56996

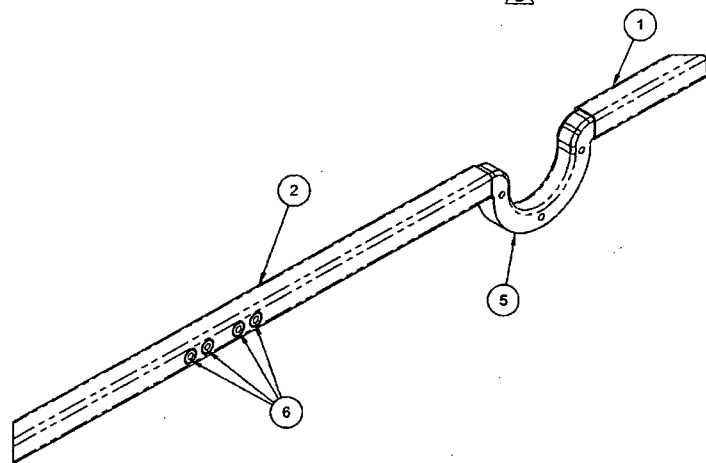
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74807

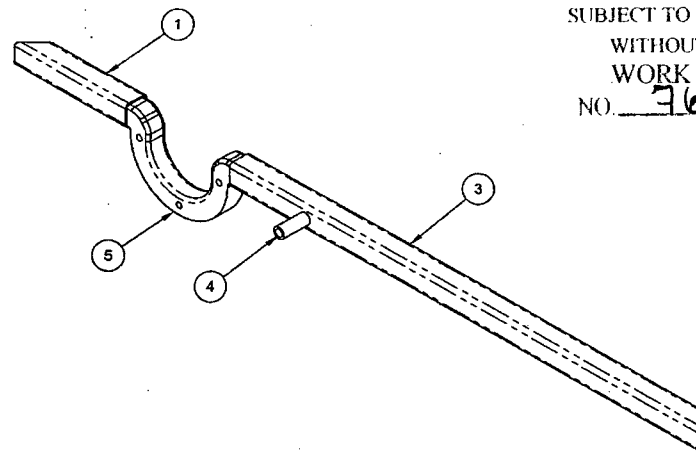
8

x3

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76541 M.L.S

11/11/16

RELEASED
2011-01-18
MJS

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	K	DRAWING NO.	REV. B
MFG. APPR.	MJS	D4034	SHEET 1 OF 4
APPROVED	MJS	TITLE	SCALE
DE APPR.	MJS	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

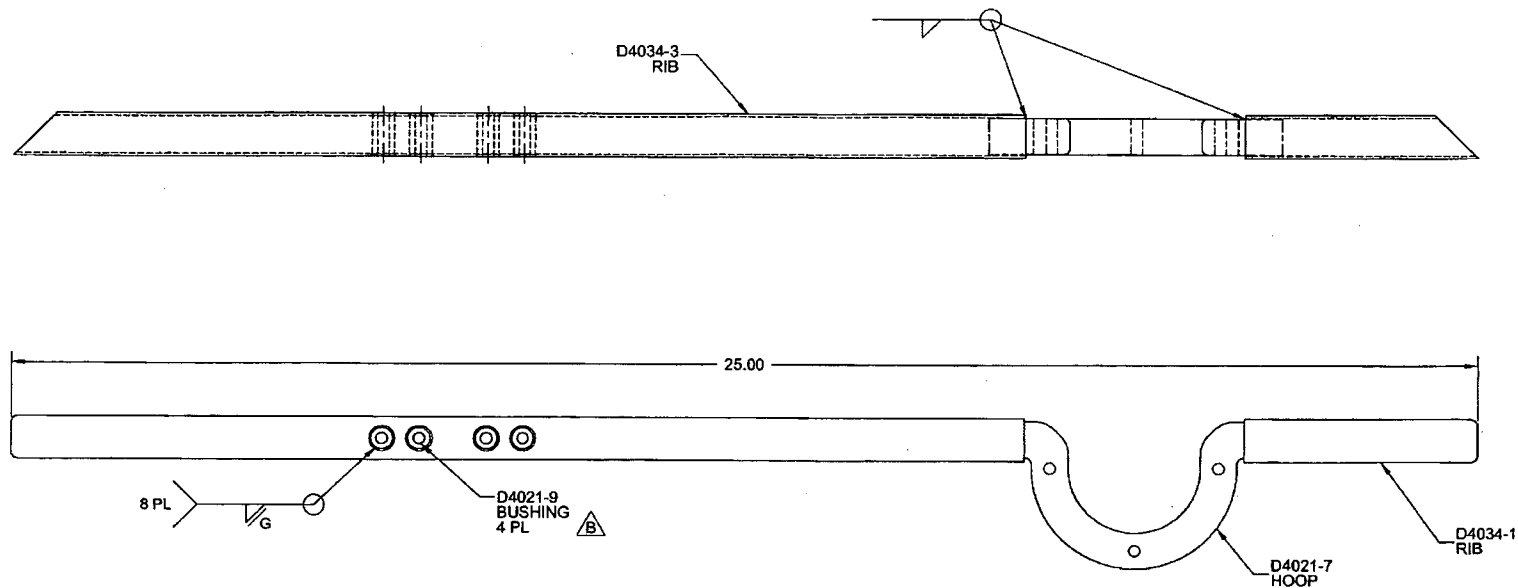
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76541



D4034-041 AFT UPPER RIB ASSY

RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	AS	D4034	SHEET 2 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	UPPER RIB ASSY, BASKET BASE	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

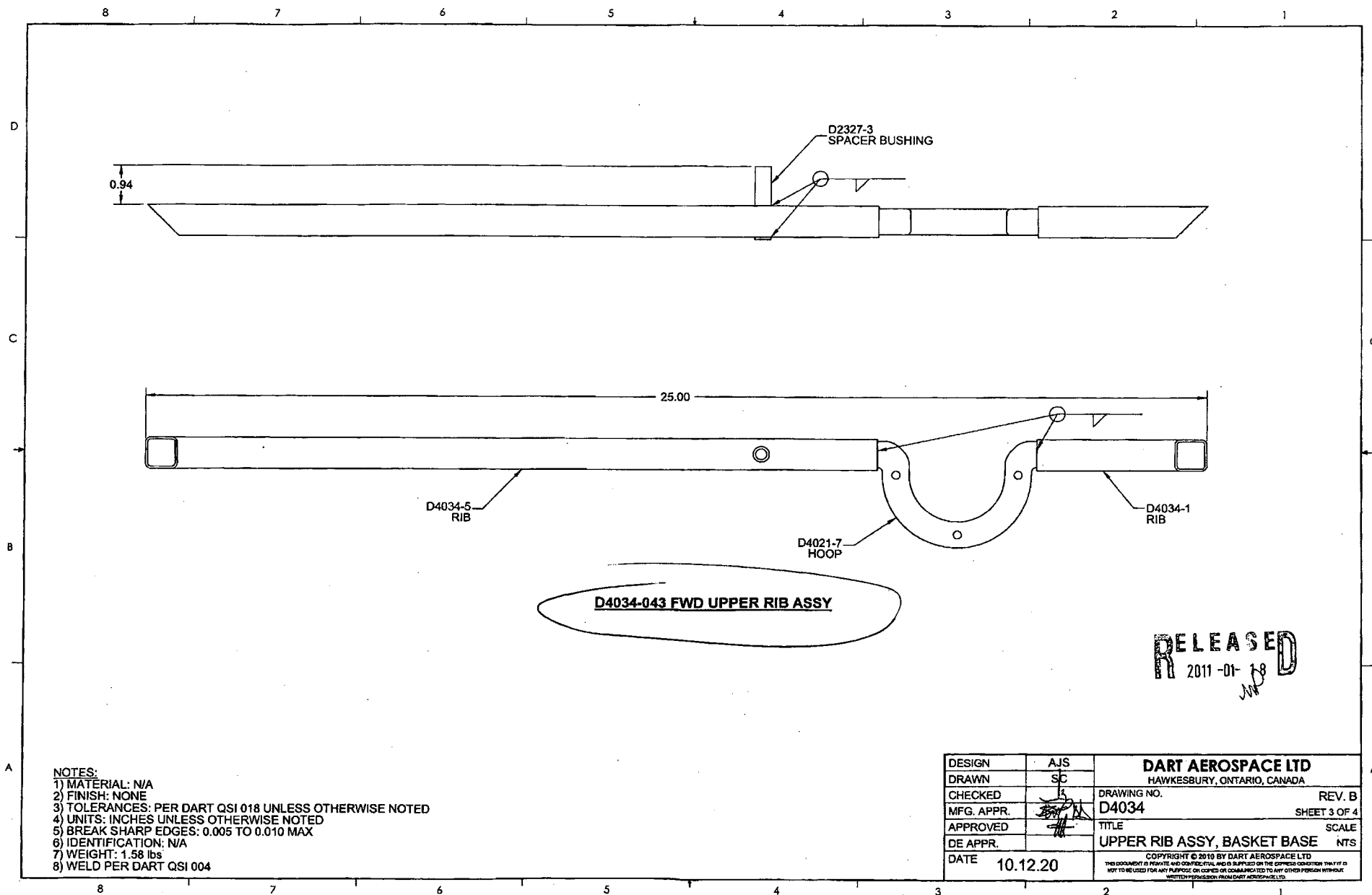
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76541



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

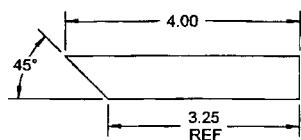
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

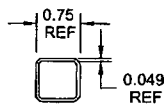
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76541



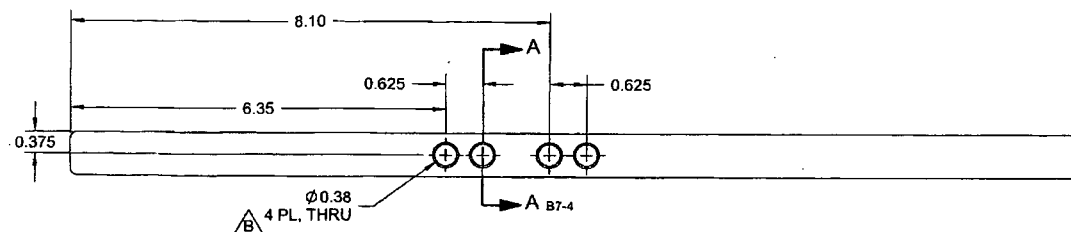
D4034-1 RIB



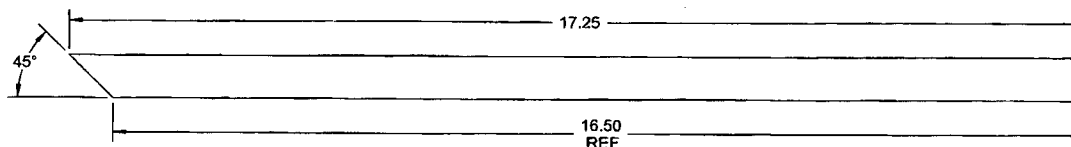
BREAK EDGE
0.030 X 45°
TYP



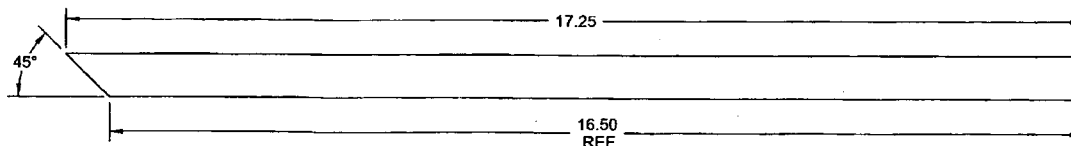
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



RELEASED
2011-01-10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750V.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D4034	SHEET 4 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	UPPER RIB ASSY, BASKET BASE	NTS
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